

**Aero Design Ltd.****Work Order Control Sheet**Work Order#: **2016-82** Date Opened: **30 May 2016** Title: **Assembly**Aircraft OEM: **Eurocopter** Aircraft Model: **AS350** Product Type: **Cargo Basket** Product Model: **LH Medium** Quantity: **1****Work Order Contents**

Work Order/Build Sheets (Procedures Provided)  
Additional Work Sheets (Standard Practice)  
Drawings (See List Below)  
Parts Distribution Sheet  
Sub Component Tags  
Completed Certification  
Time Sheet (R&D)  
Notes

Initial or N/A

JC
N/A
JC
JC
N/A
JC
N/A
N/A

**Build Sheet Contents**

Tasks Initialled  
Dual Inspections Initialled

Initial or N/A

JC
JC

**Drawing List**

Drawing #	Rev #	Description	Initial or N/A
76410	3	Basket Assembly	JC
70405	4	Lid Walkway Mod.	JC
84240	0	Lid Brace Installation	JC
84255	2	Handle Installation	JC
76427	2	Placard	JC

**Traveller**

Install walkway on lid  
Install lid on basket body  
Re-tap mounting lug holes and install mount lugs  
Install handle brackets  
Install handle  
Install lid prop  
Install data plate

Initial or N/A

DB
DB
DB
DB
DB
DB
DB

**Component Completion**

Quantity Complete on This Work Order  
Quantity Incomplete on This Work Order  
Further Processing Required Before Release  
Release to Stock as Components

As Instructed

1
0
N/A
N/A

**Certification**

Form One Completed  
Serviceable (Green) Tag Completed  
In Process (Yellow) Tag Completed  
Unserviceable (Red) Tag Completed  
Parts Placed in Stores for Distribution

Initial or N/A

JC
N/A
N/A
N/A
N/A

**Additional Documentation**

Documentation of a minor change  
Non-Conformance Report Required  
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

**Billing**

Local (Aero Design)  
Research and Development  
Third Party

Initial or N/A

JC
N/A
N/A

Work performed by:

Print: **D. Bartfai**Sign: SCA: **AD07**Date: **30-May-16**

ICC / Dual Inspection performed by:

Print: **J. Clarke**Sign: SCA: **AD02**Date: **31-May-16**

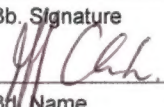
Work Order closed by:

Print: **J. Clarke**Sign: SCA: **AD02**Date: **31-May-16**

Approved Manufacturing Facility 73-04

Form 20.D.02

Rev. Original 23 Sep 2014

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. <b>AUTHORIZED RELEASE CERTIFICATE FORM ONE</b>			3. Form Tracking No. <b>2016-0071</b>
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2016-82</b>
6. Item	7. Description <b>Cargo Basket</b>	8. Part Number <b>76410-01-02</b>	9. Qty. <b>1</b>	10. Serial/Batch No. <b>76402-40</b>	11. Status/Work <b>New</b>
12. Remarks <b>Modified with walkway on lid and front end cutout IAW DCL704</b>					
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			<del>14a. <input type="checkbox"/> CAR 571.10 Maintenance Release  <input type="checkbox"/> Other regulation specified in block 12          Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.</del>		
13b. Signature  <b>AD 73-04 02</b>		13c. Approved Organization Number <b>AMF 73-04</b>		<del>14b. Signature 14c. Approved Organization Number</del>	
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mmm/yyyy) <b>30 May 2016</b>		<del>14d. Name 14e. Date (dd/mmm/yyyy)</del>	
<b>Installer Responsibilities</b> This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

**BRAINERD**



WO#

Approved Manufacturing Facility 73-04

Rev. Original 27 May 2013





## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: HANDIE ASSY (MG) No. of pieces: 1

Manufacturer: AERO DESIGN LTD.

Part No.: 84261-01 Serial No.: N/A

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2016-52

Remaining Tasks to be Performed: NONE

Signature: [Signature]

Date: 06 MAY 2016 Lic. No. / SCA AD 73-04 02

Serviceable



## **Aero Design Ltd.**

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

**Serviceable**

**Remarks**

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Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC

V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: N/A

Aircraft: Multiple

Model: Multiple

Description: 5 7/8" x 10' Aluminum Checkerplate .065"

Supplier: Daigle Marine

Color: N/A

WO#: N/A

PO# 16017



## Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity:

25

Part

MS20001P4-12000

Aircraft:

All

Model: All

Description:

Hinge

Supplier:

GKN Bandy

Color:

N/A

WO#:

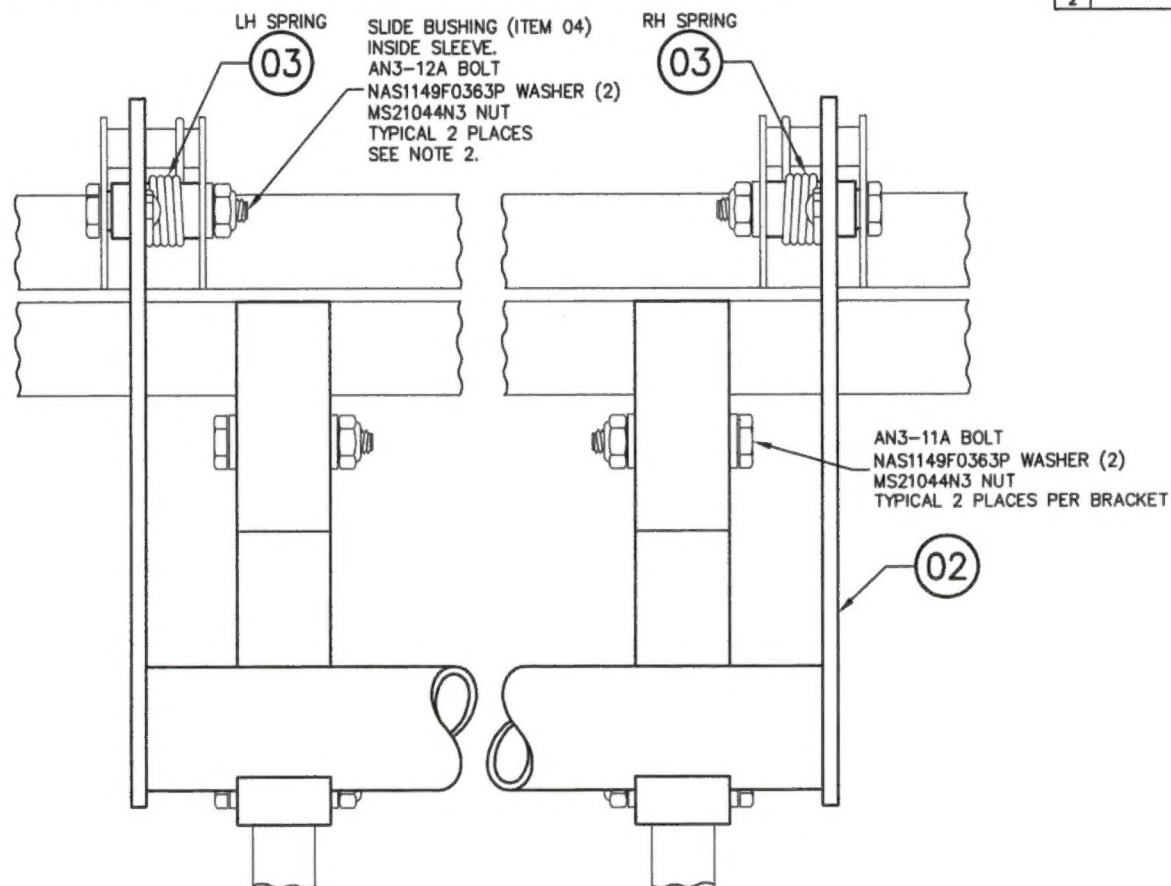
N/A

PO# 15069

2016-82

## NOTES:

1. THIS DRAWING IS AN ALTERNATE CONFIGURATION FOR THE HANDLE INSTALLATION SHOWN ON DRAWING 36255.
2. GREASE BUSHING (ITEM 04) USING MOBILGREASE 28 OR EQUIVALENT PRIOR TO INSTALLATION.

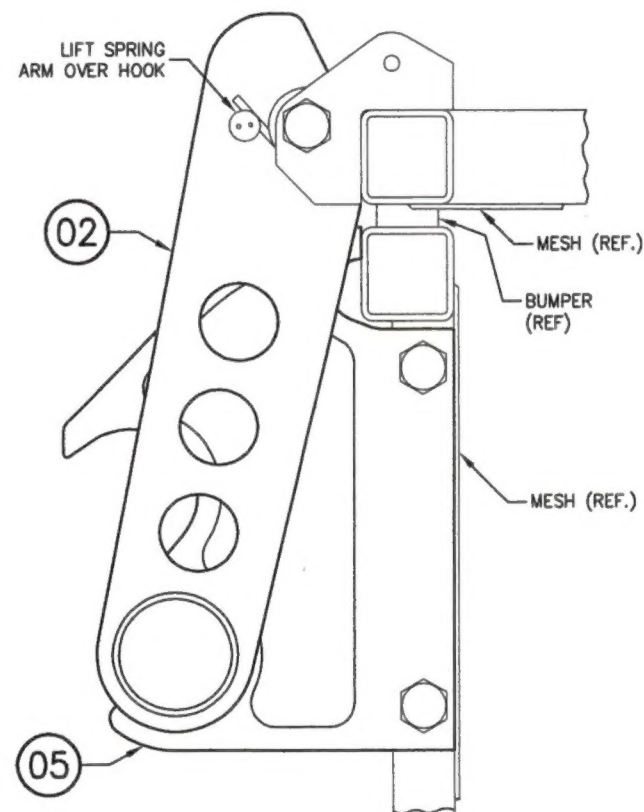


## (01) HANDLE INSTALLATION

A/R	MOBILGREASE 28		GREASE	MIL-PRF-81322F
4	AN3-11A		BOLT	
2	AN3-12A		BOLT	
10	NAS1149F0363P		WASHER	
6	MS21044N3		NUT	
2	84267-01	05	BRACKET	
2	36275-01	04	BUSHING	
2	36278-01	03	SPRING (1 LH, 1 RH)	
1	84261-01	02	HANDLE BAR ASSEMBLY	
	84255-01	01	HANDLE INSTALLATION	
01	PART NO.	ITEM	DESCRIPTION	MATERIAL
QTY.	LIST OF MATERIALS			

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 36255	BJC	NOV 03/09
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; ADD NOTE 2; HARDWARE UPDATED	BJC	MAR 13/14



APPROVALS	DATE
DRAWN: JEFF CLARKE	03 NOV 2009
CHECKED: E. BURGOIN	

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES.

TOLERANCES ON:  
DECIMALS ANGLES  
X.XXX  $\pm 0.010$   $\pm 1/2^\circ$   
X.XX  $\pm 0.03$   
X.X  $\pm 0.1$



**AERO DESIGN LTD.**

9888A MALASPINA ROAD  
POWELL RIVER, BC, CANADA, V8A 0G5  
TEL: 604.463.2376 www.aerodesign.ca

**HELICOPTER CARGO BASKET  
HANDLE BAR INSTALLATION**

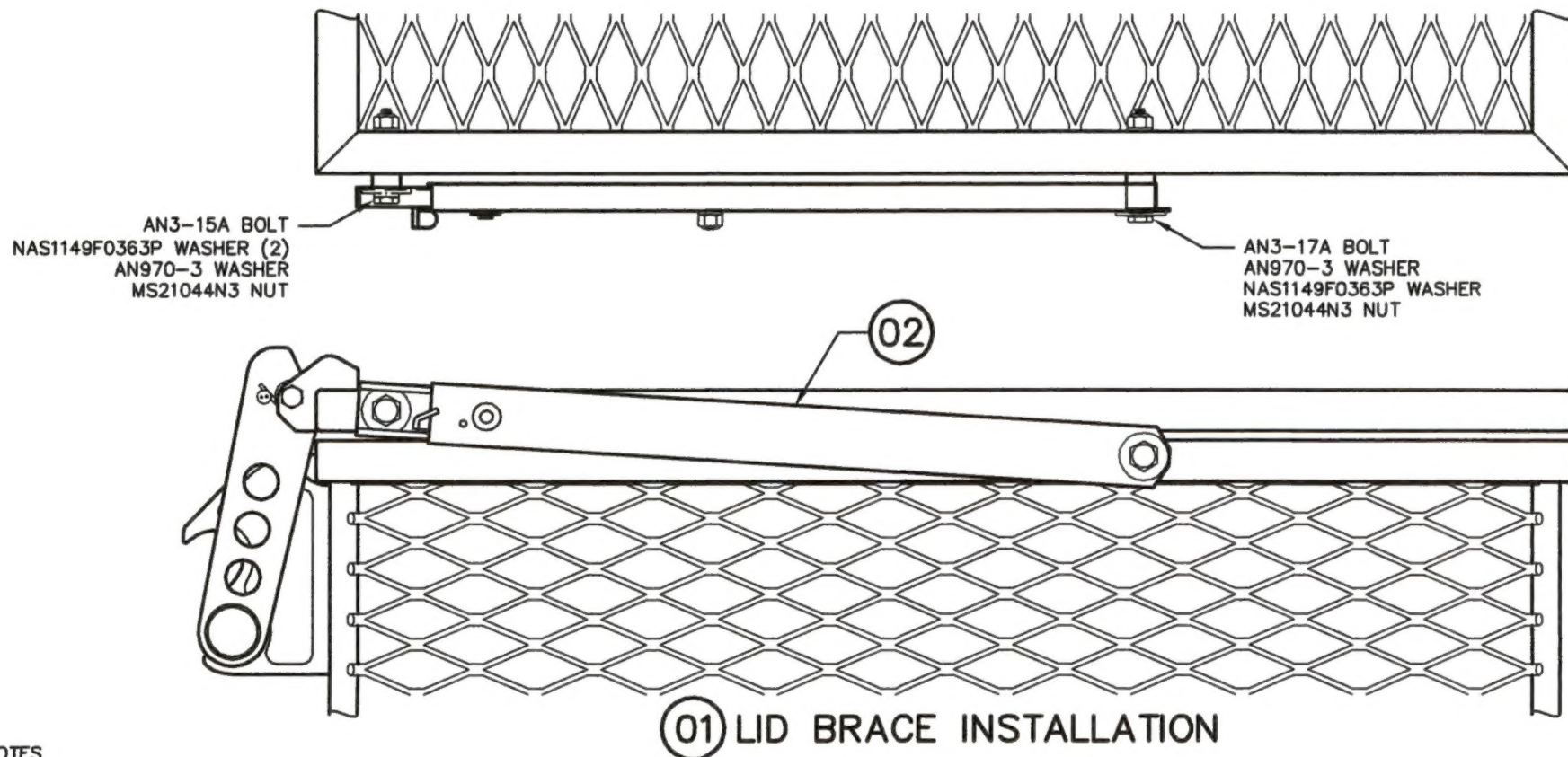
SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84255	2



2016-82

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*



## NOTES

- THIS DRAWING APPLIES TO ALL AERO DESIGN LTD. CARGO BASKET ASSEMBLIES.  
LID PROP IS TO BE INSTALLED ON THE FORWARD END OF THE BASKET AS INSTALLED ON THE HELICOPTER.

2	MS21044N3		NUT
3	NAS1149F0363P		WASHER
2	AN970-3		WASHER
1	AN3-17A		BOLT
1	AN3-15A		BOLT
1	36280-01	02	LID BRACE ASSEMBLY
1	84240-01	01	LID BRACE INSTALLATION
01	PART NO.	ITEM	DESCRIPTION
QTY.	LIST OF MATERIALS		

APPROVALS	DATE
DRAWN: JEFF CLARKE	21 MAY 2014
CHECKED: JASON REKVE	21 MAY 2014

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES.  
TOLERANCES ON:  
DECIMALS ANGLES  
X.XXX  $\pm 0.010$   $\pm 1/2^\circ$   
X.XX  $\pm 0.03$   
X.X  $\pm 0.1$



**AERO DESIGN LTD.**

9888A MALASPINA ROAD  
POWELL RIVER, BC, CANADA, V8A 0G3  
TEL: 804.483.2376 www.aerodesign.ca

**HELICOPTER CARGO BASKET  
ALL MODELS  
LID BRACE INSTALLATION**

NOT TO SCALE	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A4	84240	0

2016-82

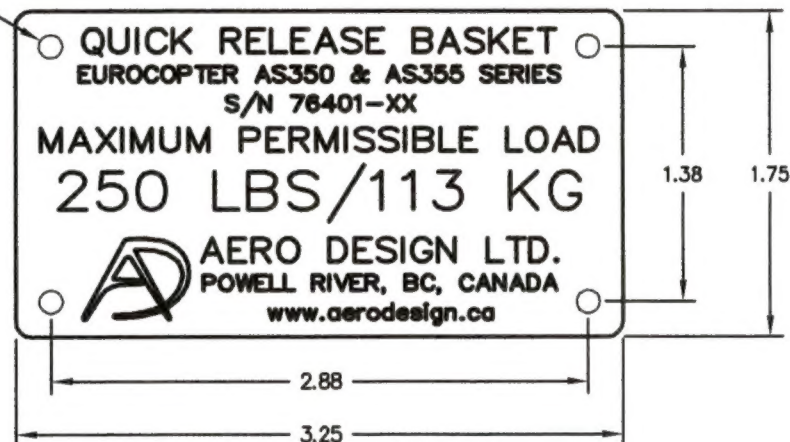
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	INCREASE LOAD TO 250 LBS / 113 KG, ADD LEFT PLACARD (02)	BJC	JAN 27/10
2	UPDATE TITLE BLOCK; UPDATE ADDRESS AND LOGO; MAT'L THICKNESS CHANGED	BJC	10/07/2014

## NOTES

1. ENGRAVE 0.007 DEEP AS FOLLOWS:  
 "QUICK RELEASE BASKET" - 0.125 HIGH  
 "EUROCOPTER AS350 & AS355 SERIES" - 0.080 HIGH  
 "S/N 76401-XX" - 0.080 HIGH  
 "MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH  
 "250 LBS/113 KG" - 0.200 HIGH  
 "AERO DESIGN LTD." - 0.125 HIGH  
 "POWELL RIVER, BC, CANADA" - 0.080 HIGH  
 "www.aerodesign.ca" - 0.080 HIGH

2. ON 76427-02: S/N IS 76402-XX.


DRILL #30 (0.129)  
4 PLACES



01 PLACARD  
02 PLACARD

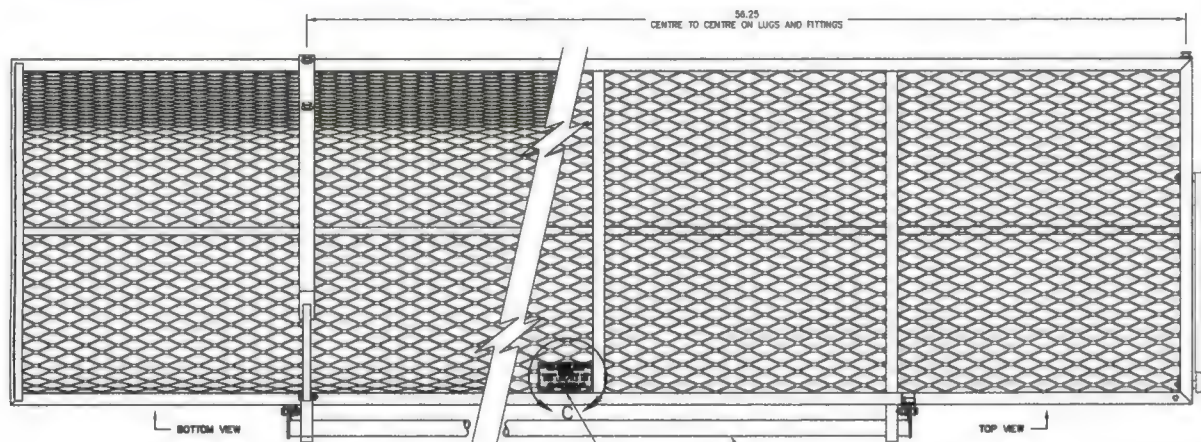
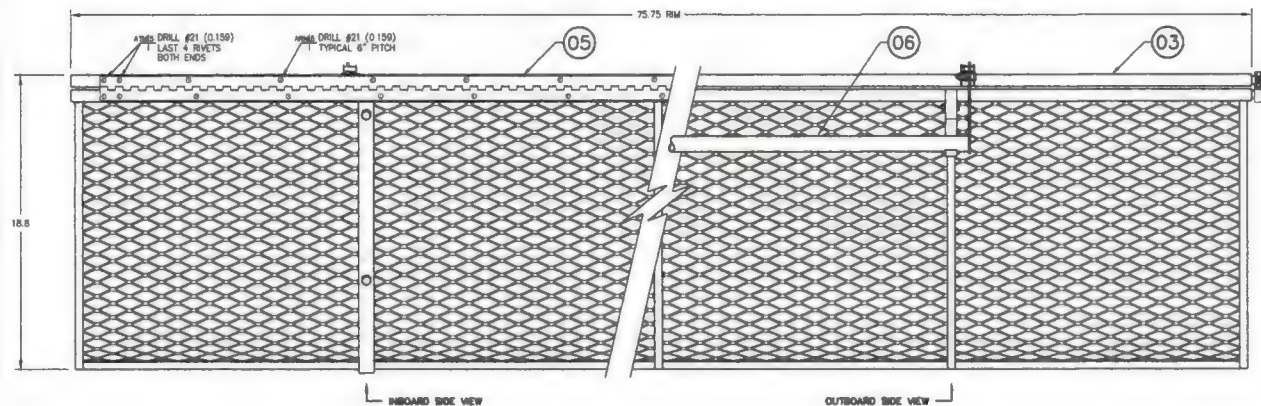
76427-02	02	PLACARD (LH)	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
76427-01	01	PLACARD (RH)	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

## LIST OF MATERIALS

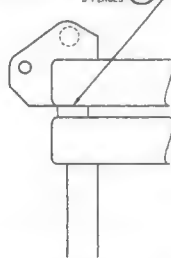
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	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS      ANGLES X.XXX ±0.010      ±1/2° X.XX ±0.03 X.X ±0.1		<b>EUROCOPTER AS350 &amp; AS355 SERIES</b> <b>QUICK RELEASE CARGO BASKET</b> <b>PLACARD</b>			
	SCALE 1 : 1 SHEET 1 OF 1		DWG. SIZE <b>A4</b>	DWG. NO. <b>76427</b>	REV. <b>2</b>	



2016-82

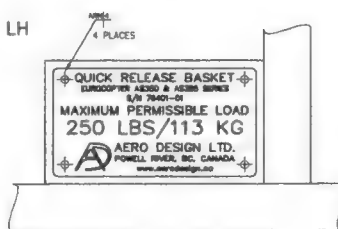


FILL 1/4" HOLE WITH COMMERCIAL SILICONE SEALANT  
INSERT BUMPER INTO HOLE  
3 PLACES



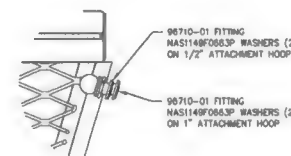
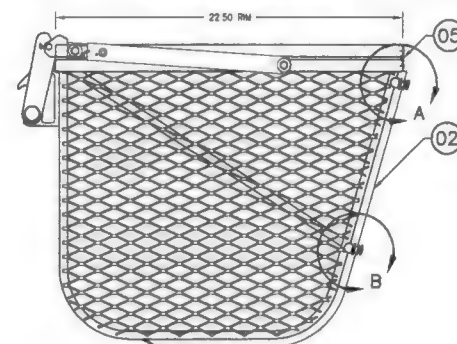
**BUMPER INSTALLATION**  
SCALE 1 : 1

**76410-01-01 CARGO BASKET ASSEMBLY - RH**  
SHOWN  
**76410-01-02 CARGO BASKET ASSEMBLY - LH**  
OPPOSITE

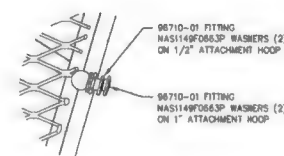


**DETAIL C**  
SCALE 1 : 1  
LOOKING AT PLACARD BRACKET

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	RR	14 JAN 06
1	ADDED LH ASSEMBLY	RR	05 MAR 09
2	CHANGED HANDLE CONFIGURATION	BJC	27 JAN 10
3	UPDATE TITLE BLOCK ADD ALTERNATE RIVETS; HARDWARE P/N'S UPDATED, CHANGE BRACE ASSEMBLY TO INSTALLATION	BJC	16/07/2014



**DETAIL A**  
SCALE 1 : 2  
TYPICAL FRONT AND REAR



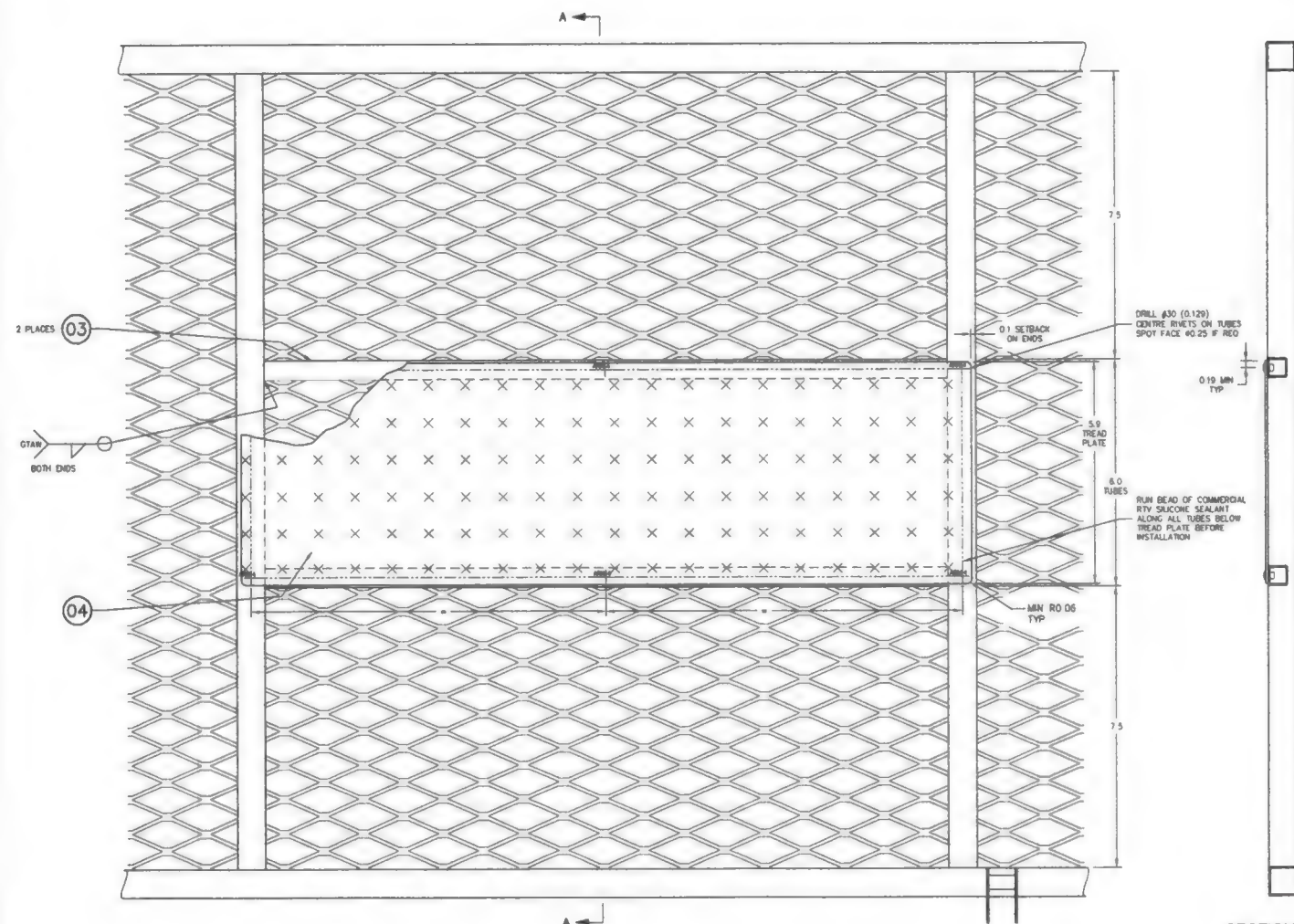
**DETAIL B**  
SCALE 1 : 2  
TYPICAL FRONT AND REAR

NOTE:  
1 ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS SHEETS.

A/R	A/R	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	4	76410-01-01	WASHER			
1	4	76410-01-02	FITTING			
1	4	CR3213-5-02	CHERRY RIVET			
1	4	CR3213-5-02	CHERRY RIVET			
1	4	CR3213-4-02	CHERRY RIVET			
1	3	49205-14	07 BUMPER			
1	1	76427-02	07 PLACARD			
1	1	76427-01	07 PLACARD			
1	1	84255-01	06 HANDLE BAR INSTALLATION			
1	1	MS20001P4	05 PLAND HINGE			72.0 LONG
1	1	84240-01	04 LID BRACE INSTALLATION			
1	1	69812-01	03 BASKET LID ASSEMBLY			
1	1	76411-01-02	02 BASKET BODY ASSEMBLY (LH)			
1	1	76411-01-01	02 BASKET BODY ASSEMBLY (RH)			
1	1	76410-01-02	01-02 CARGO BASKET ASSEMBLY - LH			
1	1	76410-01-01	01-01 CARGO BASKET ASSEMBLY - RH			
01	01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC
QTY	QTY					

BASIC CODE	DASH NO. FOR DIAMETER	DASH NO. FOR LENGTH	APPROVALS	DATE
REF: NAS 523	h=H/D HEAD NEAR SIDE f=H/D HEAD FAR SIDE		DRAWN: R RATHWELL	14 JAN 08
C=COUNTERSUNK D=DIMPLE DIT=1/8" OF SHEETS TO BE DIMPLED			CHECKED: E. BURGOIN	
BASIC CODES: BJ = MS20470AD BB = MS20426AD ARH = CR3213 ATM = CR3523	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1	INSTALL NEW RIVET REMOVE/REPLACE RIVET EXISTING RIVET		
<b>AERO DESIGN LTD.</b> 8088A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 804.488.8876 www.aerodesign.ca				
<b>EUROCOPTER AS350 &amp; AS355 SERIES QUICK RELEASE CARGO BASKET CARGO BASKET ASSEMBLY (MEDIUM)</b>				
SCALE 1 : 4	DWG. NO.	REV		
SHEET 1 OF 1	A1	76410	3	

2016-82



(01) BASKET LID ASSEMBLY

SECTION A-A

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL MEDIUM AND EUROCOPTER AS350 BASKETS, CHANGE TUBES	BUC	MAR 16/08
2	ADD EUROCOPTER EC135 WOODHULL DOUGLAS WOODSON BELL 206B BASKETS	BUC	DEC 4/08
3	ADD NEW #5350 AND 206L/467 MODELS	BUC	DEC 4/08
4	TITLE BLOCK UPDATED, MODEL LST REMOVED, ADD ALT RIVET, ADD NOTE 7	BUC	28/05/2014

## NOTES:

- THIS DRAWING IS AN OPTIONAL CONFIGURATION ADDING A TREAD PLATE STEP TO THE LID. THIS CONFIGURATION MAY BE APPLIED TO ANY OR ALL BAYS OF THE LID. REMAINDER OF LID ASSEMBLY IS TO BE FABRICATED IN ACCORDANCE WITH THE APPLICABLE DRAWINGS.
- TUBES (ITEM 03) MUST BE WELDED IN PLACE BEFORE MESH IS WELDED ON BOTTOM.
- REMOVE ALL BURRS AND BREAK SHARP EDGES.
- WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2885C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
- WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
- THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY. INSTALL TREAD PLATE AFTER POWDER COATING.
- WIDTH AND POSITION OF LID STEP MAY BE ADJUSTED TO MATCH LID DOOR INSTALLED IN ACCORDANCE WITH DRAWING 70402 ON ADJOINING BAY OF THE LID.

A/R	CR3213-4-02	BLIND RIVET	ALTERNATE: HR3213-4-02
1	70405-04 04	TREAD PLATE	ALUMINUM
2	70405-03 03	TUBE	4130 STEEL COND N
1	SEE NOTE 02	BASKET LID ASSEMBLY	COMMERCIAL
1	70405-01 01	BASKET LID ASSEMBLY - MODIFIED WITH STEP	ML-1-8738
01	PART NO	ITEM	DESCRIPTION
QTY			

BASIC CODE REF: HAS 523 C=COUNTERSUNK D=DIMPLE DIGIT # OF SHEETS TO BE DIMPLED		DASH NO. FOR DIAMETER W=WD HEAD NEAR SIDE F=WF HEAD FAR SIDE DASH NO. FOR LENGTH		APPROVALS DRAWN: JEFF CLARKE CHECKED: E. BURGON		DATE 21 SEPT 2008	
BASIC CODES: BJ=MS20470AD BB=MS20428AD ARW=CR3213 ARW=CR3212		+ INSTALL NEW RIVET + REMOVE/REPLACE RIVET - EXISTING RIVET		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS X.XXX ±0.010 X.XX ±0.03 X.X ±0.1		AERO DESIGN LTD. 8888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 804 480.8278 www.aerodesign.ca	
CARGO BASKET LID STEP MODIFICATION				SCALE 1:1 SHEET 1 OF 1		DIM SIZE DIM NO A1 70405	
				REV 4			



## CARGO BASKET ASSEMBLY - COMMON

Complete  
(initial or SCA #)

Work Order: 2016-82

Date Open: 30 MAY 2016

AD  
73-04  
07

### 1. Lid Assembly

- a. Install lid bumpers on bottom.
  - i. Fill bumper holes with RTV silicone sealant.
  - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.
- b. Install placard on bracket on top of lid.
  - i. Locate placard on bracket.
  - ii. Drill #30 through placard and bracket, using holes in placard.
  - iii. Remove placard and de-burr holes in placard and on bracket.
  - iv. Locate placard on bracket, and cleco in place.
  - v. Rivet placard with four CR3213-4-02 CherryMax rivets.
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
  - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
  - ii. Pull tread plate from stock. Shear tread plate to length.
  - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
  - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
  - v. Mark and drill #30 holes:
    1. 0.25" from edge of tread plate, centre on cross members (0.38")
    2. 0.25" from edge of tread plate, middle of each walkway stringer
  - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides.
  - vii. De-burr holes in lid tubes.
  - viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
  - ix. Set tread plate in place, secure with clecos if necessary.
  - x. Rivet placard with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

AD  
73-04  
07

### 2. Body Assembly

- a. Install attachment fittings
  - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
  - ii. Run 3/8-24 tap into attachment lugs to clear threads.
  - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
  - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
    1. 90610 (Robinson R44) basket only:
      - a. Install 1 fitting 906?? in lower forward attachment lug only.
      - b. Install 3 96710-01 fittings in remaining locations.
  - v. Torque to ??

- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
  - i. Locate 94621-01 Brace over aft cross tube cutout
  - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
  - iii. Torque AN4 bolts to ??
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

AD  
73-04  
07

## 3. Hinge Installation

- a. Prepare hinge.
  - i. Cut hinge to length:
    - 1. 776, 906 – 54"
    - 2. 751, 803 – 70"
    - 3. 698, 764, 945 – 72"
    - 4. 784 – 90"
    - 5. 940, 946, 959 – 95"
  - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
  - i. Locate hinge on basket (standard baskets)
    - 1. centre fore/aft
    - 2. 0.15" – 0.18" up from bottom edge
  - ii. Locate hinge on basket (extra wide baskets)
    - 1. centre fore/aft
    - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
  - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
  - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
  - v. Remove hinge and de-burr holes in hinge and basket rim.
  - vi. Cleco hinge to basket with 5/32 clecos.
  - vii. Install hinge with CherryMax rivets
    - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
    - 2. CR3213-5-02 aluminum rivets – all other locations
- c. Install lid on basket
  - i. Locate lid on hinge (all baskets)
    - 1. center fore/aft
    - 2. 0.15" – 0.18" down from top edge
  - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
  - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
  - iv. Remove hinge and de-burr holes in hinge and lid rim.
  - v. Cleco lid to hinge with 5/32 clecos.
  - vi. Install hinge with CherryMax rivets
    - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
    - 2. CR3213-5-02 aluminum rivets – all other locations

## CARGO BASKET ASSEMBLY - COMMON

Complete  
(initial or SCA #)

- d. Record PO of hinge and rivets on attached material tracking list.

AD  
73-04  
07

### 4. Install Handle

#### a. Install handle brackets.

- i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
- ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
- iii. Torque AN3 bolts to ??.

#### b. Install handle

- i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
- ii. Grease two 36275-01 bushings with ??. Insert into bushings of handle assembly.
- iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
- iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
- v. At first end, remove bolt and repeat step iv.
- vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
- vii. Torque AN3 bolts to ??.

#### c. Check handle

- i. Operate handle to ensure handle does not bind and springs hold handle in.
- ii. Snap handle into brackets to ensure handle locks.

- d. Record PO/WO of all parts used in steps above on attached material tracking list.

AD  
73-04  
07

### 5. Install lid brace

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to ??
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

## CARGO BASKET ASSEMBLY - COMMON

Complete  
(initial or SCA #)  
\_\_\_\_\_

### 6. Final Inspection

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
  - i. Bolts are tight
  - ii. Rivets are installed correctly
  - iii. Handle operates correctly
  - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.

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73-04  
02



## CARGO BASKET ASSEMBLY - COMMON

AS350 LH MED

w/w CUT OUT

### General

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

#### **Bell 206L/407** – Right side only

69810, Revision 3 – Standard Low Mounted Basket

94510, Revision 0 – Extra-Wide Low Mounted Basket

94610, Revision 0 – Extra-Wide Low Mounted Ski Basket

76610, Revision 0 – High Mounted Ski Basket

#### **Eurocopter AS350/AS355** – left or right

77610, Revision 1 – Short Basket

→ 76410, Revision 3 – Medium Basket (left or right)

78410, Revision 2 – Long Basket

94010, Revision 0 – Extra Large (ski) Basket

#### **Robinson R44** – left or right

90610, Revision 0 – Standard Basket (left or right)

#### **Bell 206B** – right side only

80210, Revision 0 – Short Basket

80310, Revision 0 – Medium Basket

81110, Revision 0 – Long Basket

#### **Bell 429** – right or left

95911, Revision 0 – Standard Basket

#### **Bell Medium** – left or right

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

#### **MD600**

82811, Revision 0 – Standard Basket

#### Options

→ 70405, Revision 3? – Lid Walkway

4 pc.

Work Order: 2016-82Date Opened: 30 MAY 2016Material Tracking Sheet  
Eurocopter AS350 / AS355  
Medium Basket Assembly

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>		76410-01-	<b>Cargo Basket Assembly</b>	(-01 RH, -02 LH)	<u>S/N 76402-40</u>
<b>Step 1</b>				<i>Lid Assembly</i>		
	. 1		69812-01	Basket Lid Assembly		<u>2016-55</u>
Step 1.a.	. . 3		49205-14	Bumper	Argus Industries Bumper	
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 1.b.	. . 1		76427-01	Placard (right)	0.063 Sheet, 6061-T6 Aluminum	<u>N/A</u>
	. . 1		76427-02	Placard (left)	0.063 Sheet, 6061-T6 Aluminum	<u>2015-03</u>
	. . 4		CR3213-4-02	Cherry Rivet		<u>15086</u>
Step 1.c.	. 1		70405-01	Lid Step Modification		
(option)	. . 1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	<u>16017</u>
	. . A/R		CR3213-4-02	Cherry Rivet		<u>15086</u>
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
<b>Step 2</b>				<i>Basket Assembly</i>		
Step 2.a.	. 1		76411-01-XX	Basket Body Assembly		<u>2016-69</u>
	. . 4		96710-01	Fitting	Alternate: Ancra 40088-14	
	. . 8		NAS1149F0663P	Washer		
<b>Step 3</b>				<i>Hinge Installation</i>		
	. 1		MS20001P4	Piano Hinge	72"	<u>15069</u>
	. 8		CR3523-5-02	Cherry Rivet		<u>15086</u>
	. A/R		CR3213-5-02	Cherry Rivet		<u>15031</u>
<b>Step 4</b>	. 1		84255-01	<i>Handle Installation</i>		
Step 4.a.	. . 2		84267-01	Bracket	Delrin, 3/4" Sheet	<u>2016-37</u>
	. . 4		AN3-11A	Bolt		
	. . 8		NAS1149F0363P	Washer		
	. . 4		MS21044N3	Nut		

Work Order: 2016-82Date Opened: 30 MAY 2016Material Tracking Sheet  
Eurocopter AS350 / AS355  
Medium Basket Assembly

2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	.. 1		84261-01	Handle Assembly		2016-52
	.. 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	
	.. 2		36275-01	Bushing	Brass, 5/16" Dia	
	.. 2		AN3-12A	Bolt		
	.. 4		NAS1149F0363P	Washer		
	.. 2		MS21044N3	Nut		
Step 5				Lid Brace Installation		
	. 1		36280-01	Brace Assembly		2016-32
	. 1		AN3-15A	Bolt		
	. 1		AN3-17A	Bolt		
	. 2		AN970-3	Washer		
	. 3		NAS1149F0363P	Washer		
	. 2		MS21044N3	Nut		
Step 6				Inspection	None	